

Work Order ID 65135

Thursday, January 06, 2011 3:27:53 PM



Page 1

Item ID: D3953-5

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Stud, Base

Stop



Start Date: 1/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-01-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3953	C

100

0.00



Doosan

Memo

0.00

Doosan Lathe

Turn as per folio FA853 & DWG

FOLIO REV: *C*

DWG REV: *C*

DEBURR

SA 11/1/19

12 *Ø*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 11/1/19

12 *Ø*

Work Order ID 65135

Thursday, January 06, 2011 3:27:53 PM



Page 2

Item ID: D3953-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Stud, Base

Start Date: 1/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

JL 11/6/19



QC

Memo

0.00

(12)

Quality Control

130

Identify as per dwg & Stock Location: *changes* 9b

0.00



Packaging

Memo

0.00

11/1/19

(120)

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/01/20 *mf*

Quality Control

mf

H-01-20

Picklist Print

Thursday, January 06, 2011 3:27:58 PM

Page 1

Work Order ID: 65135

Parent Item: D3953-5

Parent Item Name: Gas Spring Stud, Base



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
DD 10.03.02 verified by:EC

IPP Rev:B as per dwg revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R1.750

Purchased

No

100

f

4.0000

0.125

1.578947



SS 11/1/18

304 ROUND BAR 1.750

Location

Loc Qty

Loc Code

MAT029

4

113295

4

112939



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

DART AEROSPACE LTD		Work Order:	65135
Description: Gas Spring Stud, Base		Part Number:	D3953-5
Inspection Dwg: D3953 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.813	+/-0.010	0.813	/		Uel	SA-8
Ø0.194	+0.004/-0.001	Ø.194	/			
0.75	+/-0.030	0.750	/			
0.375	+/-0.010	0.370	/			
0.38	+/-0.030	0.379	/			
0.875	+/-0.010	0.876	/			
1.63	+/-0.030	1.631	/			
1/4-28 UNF-2A	Max = 0.2668 Min = 0.2635	0.265	/		Mic	SA-5
R0.06	+/-0.030	0.05	/			
Ø0.098	+0.004/-0.001	Ø.100	/			
Ø0.250	+/-0.010	0.247	/		Mic	SA-5
0.170	+/-0.010	0.170	/		Uel	
0.330	+/-0.010	0.330	/			
0.13	+/-0.030	0.131	/			
1.44	+/-0.030	1.441	/			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/1/18	Date:	11/6/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.11	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

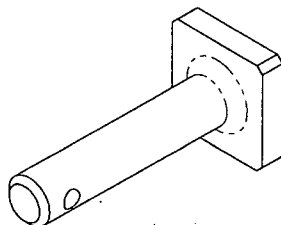
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

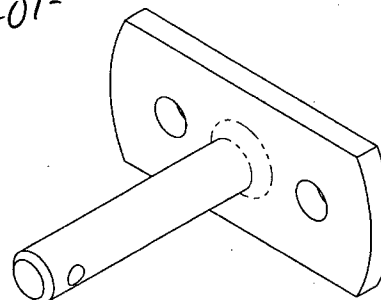
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65135 *3811-01-7*



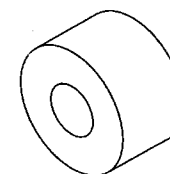
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



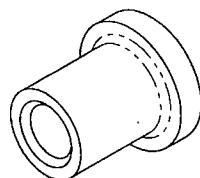
D3953-5 GAS SPRING STUD, BASE



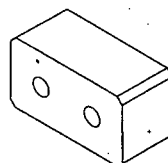
D3953-7 GAS SPRING SPACER



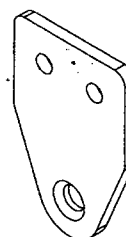
D3953-9 GAS SPRING WASHER



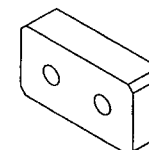
D3953-11 GAS SPRING SPACER



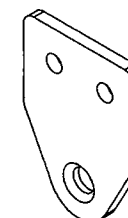
D3953-13 GAS SPRING SPACER
(FULL LID)



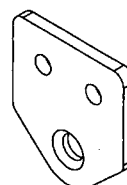
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
2010-02-26

C	PARTS -19 & -21 ADDED (SHT 1 & 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYMM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1 DIM 0.05 MIN WAS 0.13. MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 REV. C SHEET 1 OF 4 TITLE GAS SPRING LID COMPONENTS SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

Dart Aerospace Ltd

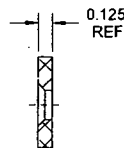
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

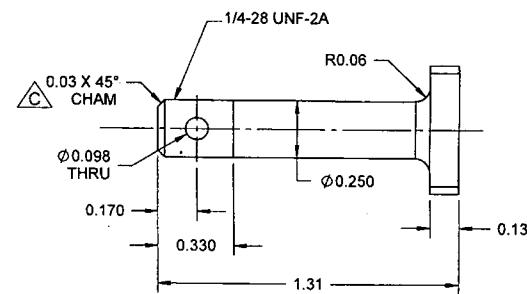
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

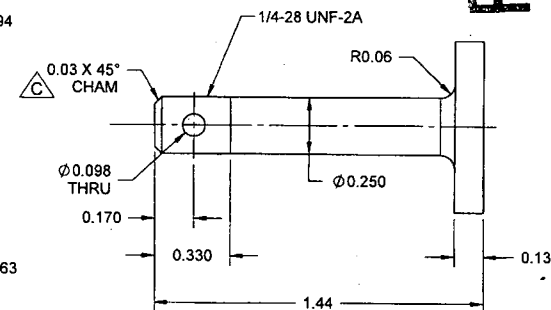
NOTE: Date & initial all entries



D3953-1 GAS SPRING BRACKET
(FULL LID)



RECEIVED
2010-02-26



2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
 -3: 0.03 lbs
 -5: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. C
DRAWN	JPH		SHEET 2 OF 4
CHECKED	<i>JP</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		

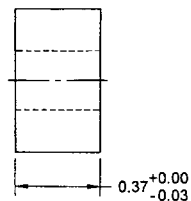
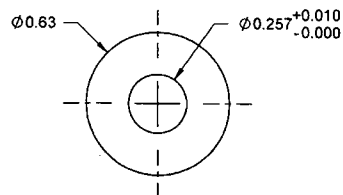
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

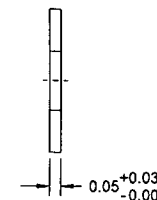
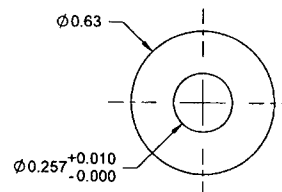
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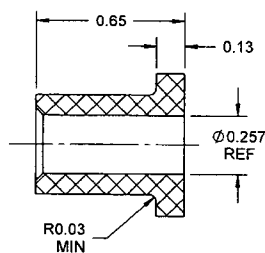
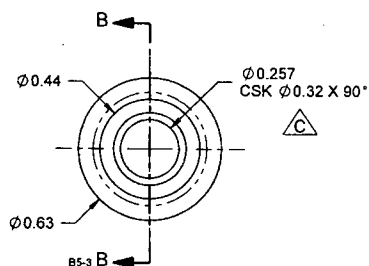
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

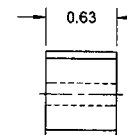
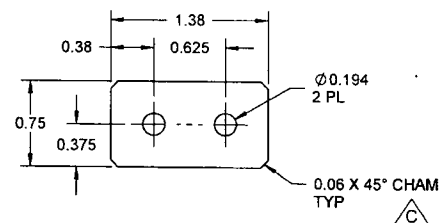


D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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